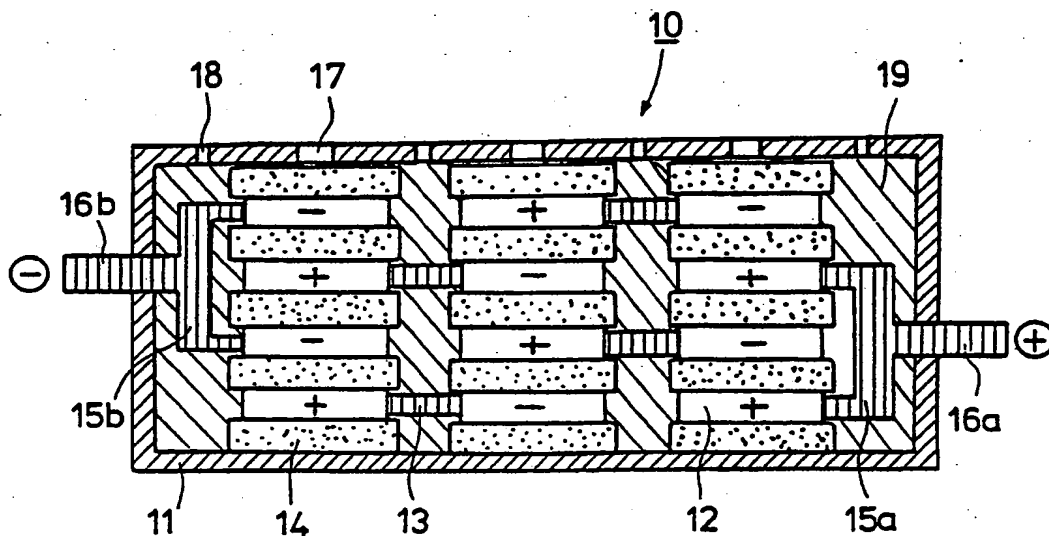




## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

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(54) Title: STORAGE BATTERY



## (57) Abstract

Storage battery (10), comprising one or several cells enclosed in a housing (11), each cell containing electrolyte and monopolar and bipolar plates (12, 13) coated with positive and/or negative active mass and separated by means of separator plates (14), and requisite electrically conductive connectors connecting the plates and/or cells. The wall separating or sealing off each cell from adjacent cells and/or from the housing (11) has been formed by filling the spaces around and/or in the interstices of the plate stacks with an electrically insulating and electrolyte-impermeable substance (19) which has been cured directly in situ for forming tightly sealing and/or insulating walls.

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## 1 Storage battery

5 The present invention concerns a storage battery comprising one or several cells enclosed in a housing, each cell containing electrolyte and, monopolar or bipolar plates coated with positive and/or negative active mass and separated by separator plates, and requisite electrical connectors connecting with each other the cells  
10 and/or plates.

Traditional lead storage batteries usually consist of plates enclosed in a cell and immersed in an electrolyte which have a current-carrying conductor part, a plate frame made of lead or of  
15 a lead alloy, and active mass, which usually has been pasted onto the plate frames. The plate frames have lugs on their margins by which they are soldered to current busbars of lead, these in their turn being welded to each other through the cell partitions. When the storage battery is being discharged with high current, the  
20 resistance of the plate frames limits the operation of the storage battery in the way that only the active mass in the vicinity of the plate lugs will be efficiently utilized. In order to ensure adequate current passage, an unnecessarily high amount of lead has to be provided on the plate frames, and this increases the weight  
25 of the storage battery. Furthermore, in conventional storage batteries battery boxes are used in which the partitions between cells are prefabricated. Not very many current leads can in practice be carried through the partitions to carry current from one cell to the other. The deep battery box with its partitions is a plastic  
30 component which is in itself expensive and difficult to manufacture.

Storage battery designs deviating from what is conventional are also known in the art, in which part of the electrodes have been made bipolar. The positive and negative active masses of mutually  
35 adjacent cells have been pasted on one and the same plate frame, which has in connection with die casting been fixed at its centre

1 in a plastic frame. These plastic frames have been welded to each  
other with ultrasonics so that the cell partitions, and at the  
same time the entire storage battery, are sealed tight. The advan-  
2 tage of a storage battery of this type is low internal resistance  
5 and uniform use of the active material, a consequence of the contact  
from one cell to the other which is divided over the whole of the  
partition. The drawback is an exceedingly high number of welds  
that have to be produced in a welding process, whereby the manufac-  
turing costs will be high.

10 So-called recombination storage batteries are also known in the  
art (see e.g. EP 01 07 976), in which the plates carrying positive  
and negative active mass in adjacent cells have been connected  
with each other by means of bridging pieces. Said bridging pieces  
15 may in fact consist of lands connecting plate parts belonging to  
adjacent cells. In this storage battery type there are no tightly  
sealed partitions at all between the plate stacks constituting  
adjacent cells, there is merely an air gap. This structure is only  
possible in the case that the electrolyte has been absorbed into  
20 the separator plates and active masses. The drawbacks include  
current leakage on the surface of the leads along the electrolyte  
film; this drawback is the greater the broader the connecting pieces  
between plates. The current distribution is also still partially  
non-uniform because all current must pass through said lands.

25 The object of the invention is a storage battery in which the  
drawbacks associated with the storage batteries described above  
have been avoided and a number of significant advantages have been  
gained which would not be possible using structures conforming to  
30 known technology. The storage battery of the invention comprises  
one or several cells enclosed in a housing, each cell containing  
electrolyte and monopolar and bipolar plates coated with positive  
and/or negative active mass, and requisite electrically coinductive  
connectors connecting the plates and/or the cells, and the invention  
35 is characterized in that the wall separating or sealing off each  
cell from adjacent cells and/or from the housing has been formed

1 by filling the spaces around the plate stacks and/or between them  
with an electrically insulating and electrolyte-impermeable sub-  
stance which has been cured directly in situ in order to establish  
tightly sealed and/or insulating walls.

5  
Since in the storage battery of the invention the inter-cell par-  
titions are only formed after the storage battery has been assembled  
and the plate stacks have been placed in the storage battery hous-  
ing, this implies that the optimum number of current leads between  
10 plates and/or cells can be provided and they can have optimum  
shape. As a consequence, in the storage battery of the invention  
low internal resistance is attained, as well as uniform use of  
active mass, and less lead is required. Furthermore, in the storage  
battery of the invention there are fewer cast and welded joints  
15 than in conventional storage batteries, and the design of the  
battery housing is simple. Furthermore, the manufacturing of the  
storage battery of the invention is easy to automate.

In its general form, the invention comprises a storage battery in  
20 which the plate stacks have been separated from each other, or  
from the housing, by filling the empty spaces between plate stacks  
with an electrically insulating and electrolyte-impermeable sub-  
stance which has been cured in situ. Tightly sealed partitions  
between cells have thus been obtained in a simple manner. A par-  
25 ticular advantage is gained in a manufacturing technique of this  
kind owing to the circumstance that the wiring between cells can  
be as dense as ever required without interfering with or limiting  
the forming of partitions. Thus the wiring can be made optimal by  
using a great number of slender conductors which have been uniformly  
30 distributed in the interval between plates. When flowing, electri-  
cally insulating and electrolyte-impermeable substance is directed  
into the storage battery housing, even slender wiring between the  
plates will not be damaged: the wiring remains inside the partitions  
that are formed on curing and passes therethrough.

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The substance separating or sealing the cells and which is imper-

1 meable to the electrolyte is advantageously a plastic-based sub-  
stance which can be forced in liquid state into the storage battery,  
whereat it spreads uniformly and fills the empty spaces between  
plates, and becomes cured in situ. Curing may be accomplished in  
5 any way known in itself in the art, e.g. with the aid of reactions  
based on temperature, on a chemical reaction or on radiation. For  
substance which is thus cured may be used any substance which can  
be conducted into the storage battery housing in liquid state and  
cured in situ to become a wall with adequate sealing and electrical  
10 insulating properties. Suitable materials are, among others, poly-  
urethane plastics, polyester plastics, and epoxy plastics. In  
particular one may with advantage use closed-cell polyurethane  
foam plastic which is injected into the housing or into a mould  
immediately after mixing the components, in which case the foaming  
15 causes the plastic to fill the empty spaces.

According to an advantageous embodiment of the invention no pre-  
fabricated storage battery housing is needed at all if the pre-  
assembled plate stacks have been placed in a mould which is there-  
20 after injected full with curable wall material according to the  
invention, which then at the same time constitutes the storage  
battery housing.

When the sealing and insulating partitions have been formed in a  
25 manner conforming to the present invention, the storage battery  
may be filled with acid and formed in a manner known in itself in  
the art, to become a storage battery ready for use.

Although in this connection the invention is described as applied  
30 to a lead battery, it is obvious that the technique of the invention  
may also be applied to those storage batteries in which another  
material is used for storage battery plate material.

The invention is described in detail, referring to certain advan-  
35 tageous embodiments of the invention presented in the figures of  
the attached drawings, yet to which the invention is not meant to

1 be exclusively confined.

Fig. 1 presents an advantageous embodiment of the storage battery of the invention, sectioned.

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Fig. 2a presents an advantageous embodiment of the negative monopolar plate frame used in the storage battery of the invention, in top view.

10 Fig. 2b presents an advantageous embodiment of the bipolar plate frame used in the storage battery of the invention, in top view.

Fig. 2c presents an advantageous embodiment of the positive monopolar plate frame used in the storage battery of the invention, in  
15 top view.

Fig. 3 presents another advantageous embodiment of the storage battery of the invention, in vertical section.

20 In the embodiment of Fig. 1, the 6-volt storage battery of the invention in general has been denoted with the reference numeral 10. The storage battery 10 comprises one or several cells enclosed in a housing 11. Each cell contains electrolyte and monopolar plates 12 and bipolar plates 13 coated with positive and/or negative  
25 active mass and separated with separator plates 14. The storage battery 10 moreover comprises requisite, electrically conductive connectors connecting the plates 12,13 and/or the cells. According to the basic insight of the invention, the wall separating, or sealing off, each cell from adjacent cells or from the housing 11  
30 has been formed by filling the spaces around and between the plate stacks in the housing 11 with an electrically insulating and electrolyte-impermeable substance 19 which has been cured directly in situ to form tightly sealing and/or insulating walls.

35 In Fig. 5, the lugs connecting plates having the same sign are indicated with reference numerals 15a, respectively 15b. The posi-

- 1 tive terminal of the storage battery carries the reference numeral  
16a and the negative terminal, similarly, the numeral 16b. The  
reference numeral 18 indicates an injection hole through which  
electrically insulating and electrolyte-impermeably substance is  
5 conducted into the housing 11. Reference numeral 17 indicates the  
acid-filling hole through which the storage battery 10 is provided  
with acid in a manner known in itself in the art, for producing a  
storage battery ready for use.
- 10 As shown in Fig. 2a, the monopolar plate frame 12 has been provided  
with negative active mass 21, as shown in Fig. 2b, the bipolar  
plate frame 13 has been provided with positive active mass 20 and  
negative active mass 21, the intermediate part 22 being unfilled,  
and as shown in Fig. 2c, the monopolar plate frame 12 has been  
15 provided with positive active mass 20.

The electrically conductive bipolar plate 13 or bipolar plate  
lattice consists of a reticular structure containing electrically  
conductive material and of which one end 20 has been coated with  
20 positive and the other end 21 with negative active mass, and on  
which the intermediate part 22 is uncoated. A reticular structure  
of this kind is composed of an electrically non-conductive sup-  
porting structure to which have been joined electrically conductive  
wires, or an electrically conductive reticular structure.

- 25 According to an advantageous embodiment of the invention, the  
storage battery of Fig. 1 consists of monopolar and bipolar plates  
12, 13 and separator plates 14 stacked upon each other, in such way  
that in the extreme outside cells every second plate is monopolar  
30 12 and every second is the end with opposite sign of a bipolar  
plate 13. At the points between cells, the uncoated parts 22 of  
the bipolar plates 13 are in register and constitute current con-  
ductors passing through the insulating and/or sealing partition  
that is formed when the electrically insulating and electrolyte-  
35 impermeable substance 19 is cured.



- 1 In Fig. 3 is depicted the design principle of a 12-volt storage battery. The bipolar elements 32 consist of an electrically conductive plate 33 which is coated on one side with positive active mass 34 and on the other side with negative active mass 35. Between  
5 the bipolar elements 32 are placed separator plates 36 which separate the active masses of opposite signs on the surfaces of adjacent plates 33.

- The structure of the separator plates 36 is porous, and they contain  
10 part of the electrolyte acid which is required for operation of the storage battery 30. Part of the acid is of course contained in the active masses 34 and 35.

- On the ends of the bipolar element stacks are provided end plates  
15 37 and 38 which have been coated with active mass on one side only. To the end plates 37 and 38 have been attached leads or busbars 39 for taking off electric current.

- The bipolar element stack has been placed in an enclosed, gas-tight housing 31, which is provided with at least one pressure relief valve 40, which prevents damage to the housing 31 of the  
20 storage battery 30 from gas generation due to excessively violent charging or discharging.

- 25 In an advantageous embodiment of the invention, in the storage battery of Fig. 3, the bipolar plates 33 consist of tightly sealing, electrically conductive films on one side of which has been applied a coat of positive, and on the other side of negative, active mass 34,35. The storage battery is composed of monopolar plates 37,38,  
30 separator plates 36 and bipolar plates 33 stacked upon each other in the housing 31 in such manner that outermost are placed the monopolar plates 37,37 and between these the requisite number of bipolar plates 33. Each single cell is constituted by the negative monopolar plate 37 or the negative half 35 of one bipolar plate  
35 33, the positive half 34 of one bipolar plate 33 or the positive monopolar plate 38, and the separator plate 36 between them. The

1 layer separating the plate stacks from each other and/or from the  
wall of the housing 31 and/or sealing them thereagainst has been  
formed by filling the free spaces between the plate stacks and the  
storage battery housing with an electrically insulating and elec-  
5 trolyte-impermeable substance 41, whereafter this substance has  
been cured in situ to form an insulating and/or sealing layer. In  
this connection an injection hole similar to the injection hole 18  
in Fig. 1 is formed in the housing 31.

10 In the storage battery of the invention, the negative active ma-  
terial 21,35 is advantageously metallic lead, and the positive  
active material 20,34 is lead dioxide, and the electrolyte is an  
aqueous solution of sulphuric acid. For the insulating and sealing  
material 19,41 it is advantageous to use polyurethane or poly-  
15 urethane foam, or a plastic-based product which can be made flowing  
and injectable by heating and which hardens, or is cured, on cool-  
ing. One such insulating and sealing substance 19,41 is polyester  
or epoxy which hardens on injection either with the aid of a hard-  
ener or of heat treatment.

20 In an advantageous embodiment of the invention, after stacking,  
placing in the housing 11,31 and fitting the electric connections  
the empty spaces have been filled with insulating and sealing  
substance 19,41, whereafter the storage battery 10,30 has been  
25 filled with acid and formed in a way known in itself in the art.

In an advantageous embodiment, after stacking, placing in the  
housing 11,31 and fitting the electric connections the storage  
battery 10,30 has been filled with acid in such manner that all  
30 acid can be absorbed in the active materials 20,21;34,35 and in  
the separator plates 14,36 without there being so much free elec-  
trolyte in the storage battery that it could cause short-circuits  
between different cells, whereafter the storage battery has been  
formed in a way known in itself in the art and filled of its empty  
35 spaces with insulating and sealing material 19,41.

- 1 In conjunction with the cells free cavities have been left when  
applying the insulating and sealing substance 19,41 in which extra  
electrolyte may be placed.

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## 1 Claims

1. A storage battery, comprising one or several cells enclosed in a housing, each cell containing electrolyte and monopolar and  
5 bipolar plates (12,13;37,38,32) coated with positive and/or negative active mass and separated by means of separator plates (14;36), and requisite electrically conductive connectors connecting the plates and/or cells, characterized in that the wall separating or  
10 sealing off each cell from adjacent cells and/or from the housing (11;31) has been formed by filling the spaces around and/or in the interstices of the plate stacks with an electrically insulating and electrolyte-impermeable substance (19;41) which has been cured directly in situ for forming tightly sealing and/or insulating  
15 walls.
2. Storage battery according to claim 1, characterized in that said electric connections pass through the spaces around and between said plate stacks, said connections passing after the curing of the electrically insulating and electrolyte-impermeable substance  
20 (19) within or through the tightly sealing and/or insulating walls.
3. Storage battery according to claim 1 or 2, characterized in that a bipolar plate (13) consists of an electrically conductive plate or plate lattice of which one end is coated with positive  
25 active mass (20) and the other end with negative active mass (21) and on which the electric connections is constituted by an uncoated area (22) of the plate or plate lattice between the coated areas, located at the site of an insulating and/or sealing wall, produced by curing electrically insulating and electrolyte-impermeable  
30 substance (19), and passing therethrough.
4. Storage battery according to claim 3, characterized in that an electrically conductive bipolar plate (13) or bipolar plate lattice consists of a reticular structure containing electrically conductive  
35 material, of which one end (20) is coated with positive and the other end (21) with negative active mass and of which the inter-

1 mediate part (22) is uncoated.

5 5. Storage battery according to claim 4, characterized in that the reticular structure consists of an electrically non-conductive supporting structure to which have been joined electrically conductive wires or an electrically conductive reticular structure.

10 6. Storage battery according to any one of claims 1-5, characterized in that the storage battery is composed of monopolar and bipolar plates (12,13) and separator plates (14) stacked upon each other in a housing so that in the outermost cells every second plate is monopolar (12) and every second plate is the end with opposite sign of a bipolar plate (13), and that in intermediate cells there are alternatingly ends with different signs of bipolar plates  
15 (13), and that at the points between cells are the uncoated portions (22) of the bipolar plates (13) in register, forming current conductors which pass through the insulating and/or sealing partition that has been formed on curing the electrically insulating and electrolyte-impermeable substance (19).

20 7. Storage battery according to any one of claims 1-5, characterized in that the bipolar plates (33) consist of tightly sealing, electrically conductive films on one side of which has been coated positive and on the other side negative active mass (34,35), and  
25 that the storage battery is composed of monopolar plates (37,38), separator plates (36) and bipolar plates (33) stacked upon each other in a housing so that outermost are the monopolar plates (37,38) and between them the requisite number of bipolar plates (33), each one cell being formed of a negative monopolar plate  
30 (37) or the negative half (35) of a bipolar plate (33), of the positive half (34) of a bipolar plate (33) or the positive monopolar plate (38), and of a separator plate (36) between them, and that the layer separating and/or sealing off the plate stacks from each other and/or from the walls of the housing (31) has been formed by  
35 filling the free spaces between the plate stacks and the storage battery housing with an electrically insulating and electrolyte-

- 1 impermeable substance (41), which has thereafter been cured in situ to form an insulating and/or sealing layer.
- 5 8. Storage battery according to claim 6 or 7, characterized in that the plate stacks have been placed in a mould, whereby the electrically insulating and electrolyte-impermeable insulating and/or sealing substance cured in the mould at the same time constitutes the storage battery housing.
- 10 9. Storage battery according to any one of claims 1-8, characterized in that the negative active material (21,35) is metallic lead and the positive active material (20,34) is lead dioxide, and the electrolyte is an aqueous solution of sulphuric acid.
- 15 10. Storage battery according to any one of claims 1-9, characterized in that said insulating and/or sealing substance (19,41) is polyurethane or polyurethane foam.
- 20 11. Storage battery according to any one of claims 1-9, characterized in that said insulating and/or sealing substance (19;41) is a plastic-based product which can be made flowing and injectable by heating and which hardens on cooling.
- 25 12. Storage battery according to any one of claims 1-9, characterized in that said insulating and/or sealing substance (19;41) is polyester or epoxy which becomes cured after injection with the aid either of a hardener or of heat treatment.
- 30 13. Storage battery according to any one of claims 1-12, characterized in that after stacking, placing in the housing (11;31) and performing the electric connections the empty spaces have been filled with said insulating and/or sealing substance (19;41), whereupon the storage battery (10,30) has been acid-filled and formed in a manner known in itself in the art.
- 35 14. Storage battery according to any one of claims 1-12, character-

1    ized in that after stacking, placing in the housing (11;31) and  
performing the electric connections the storage battery (10,30)  
has been acid-filled in such manner that all acid may be absorbed  
in the active materials (20,21;34,35) and in the separator plates  
5    (14;36) without there being so much electrolyte in the storage  
battery that it could cause short-circuits between different cells,  
whereafter the storage battery has in a way known in itself in the  
art been formed and as of its empty spaces filled with said insu-  
lating and sealing substance (19,41).

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15. Storage battery according to any one of claims 1-14, character-  
ized in that free cavities have been left in conjunction with the  
cells when applying the insulating and/or sealing substance (19;41),  
in which extra electrolyte can be placed.

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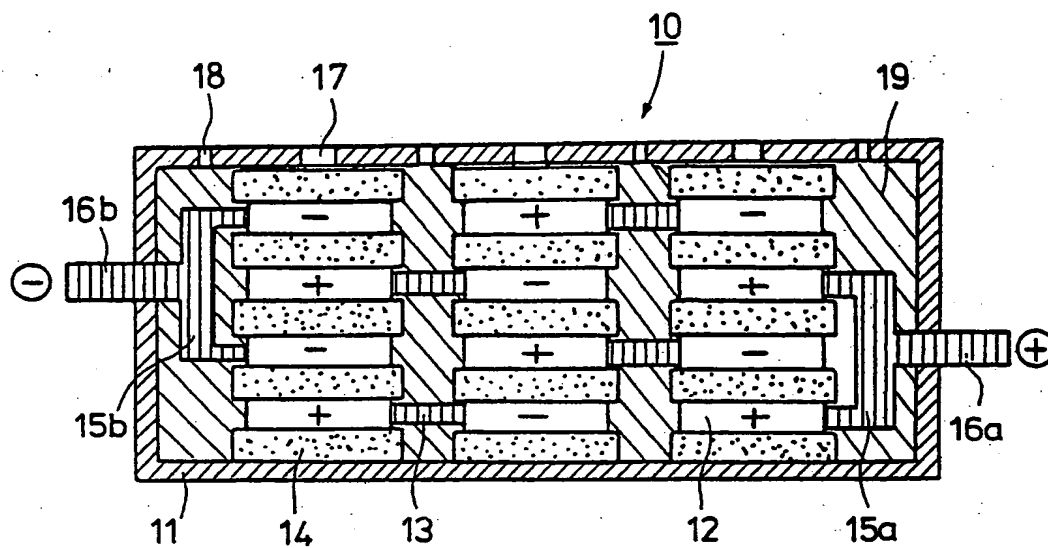


FIG. 1

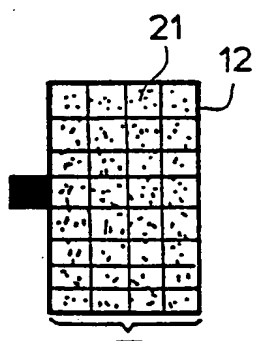


FIG. 2a

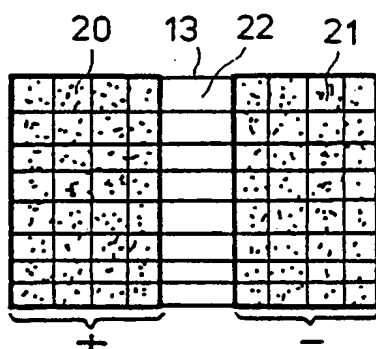


FIG. 2b

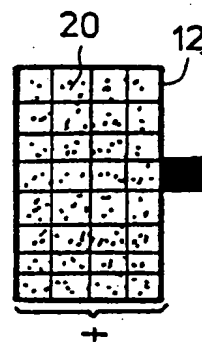


FIG. 2c



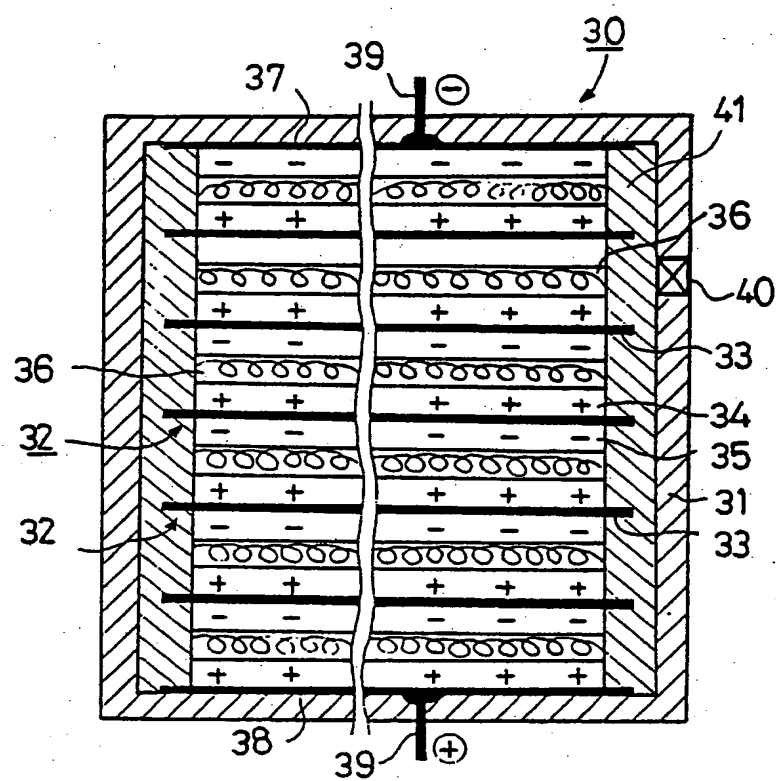
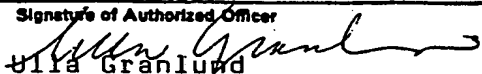


FIG. 3

# INTERNATIONAL SEARCH REPORT

International Application No PCT/FI86/00150

<b>I. CLASSIFICATION OF SUBJECT MATTER</b> (If several classification symbols apply, indicate all) *		
According to International Patent Classification (IPC) or to both National Classification and IPC		
H 01 M 10/16, 10/18 <span style="float: right;">4</span>		
<b>II. FIELDS SEARCHED</b>		
Minimum Documentation Searched *		
Classification System	Classification Symbols	
IPC 4 US C1	H 01 M 10/04, /06, /12, /16, /18, /34 429:121, 152, 153, 160, 161, 186, 210	
Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched *		
SE, NO, DK, FI classes as above		
<b>III. DOCUMENTS CONSIDERED TO BE RELEVANT *</b>		
Category *	Citation of Document, ** with indication, where appropriate, of the relevant passages **	Relevant to Claim No. **
X	US, A, 2 968 686 (J.C. DUDDY) 17 January 1961	1, 2, 7, 8, 11, 12
X	US, A, 4 331 747 (K. JULIAN ET AL) 25 May 1982 See spec. col. 7 line 11-15, claim 5. & WO, 80/02473 EP, 0028227 AU, 59921/80 AU, 531567	1, 2, 3, 4, 6, 9, 11-15
Y	GB, A, 2 158 285 (P. JARRET) 6 November 1985	3, 4, 5, 14
Y	DE, B2, 2 548 813 (N. LAHME) 23 March 1978	10
P	EP, A, 195 567 (NESTE OY) 24 September 1986	
.../...		
<div style="display: flex; justify-content: space-between;"> <div style="width: 45%;"> <p>* Special categories of cited documents: **</p> <p>"A" document defining the general state of the art which is not considered to be of particular relevance</p> <p>"E" earlier document but published on or after the international filing date</p> <p>"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)</p> <p>"O" document referring to an oral disclosure, use, exhibition or other means</p> <p>"P" document published prior to the international filing date but later than the priority date claimed</p> </div> <div style="width: 45%;"> <p>"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention</p> <p>"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step</p> <p>"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.</p> <p>"&amp;" document member of the same patent family</p> </div> </div>		
<b>IV. CERTIFICATION</b>		
Date of the Actual Completion of the International Search	Date of Mailing of this International Search Report	
1987-03-20	1987-03-23	
International Searching Authority	Signature of Authorized Officer	
Swedish Patent Office	 Ulla Granlund	

III. DOCUMENTS CONSIDERED TO BE RELEVANT (CONTINUED FROM THE SECOND SHEET)		
Category *	Citation of Document, with indication, where appropriate, of the relevant passages	Relevant to Claim No
A	US, A, 3 003 012 (J.C. DUDDY) 3 October 1961	
A	WO, A, 84/02230 (T. ERIKSSON) 7 June 1984	